

# Work Order ID 51195

August 6, 2009 2:22:54 PM

Page 1

Item ID: D3789-5

Accept

Setup Start

Revision ID: A

Stop

Item Name: Clamp

Start Date: 8/10/09 Start Qty: 12.00

Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

0.00

0.00

0.00

0.00

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut extrusion to .820"

DJP 09/08/10

12 0

110



HAAS I

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA834

Dwg Rev:

Folio Rev:

Debur

DJP 09/08/10

12

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August 6, 2009 2:22:54 PM

Page 2

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Stop

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Date:

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Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

115

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

*DIP 09/08/10*

0.00

12

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

*SP 09/08/10*

0.00

12

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

*=)*

*all*

*09-08-11*

*(12)*

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August 6, 2009 2:22:54 PM



Page 3

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

A.M 09-08-11



150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*Mask bearing bore prior to powder coat\*\*\*\*\*

START TIME: 9:20pm  
OVENTEMPERATURE: 320°C  
FINISH TIME: 9:50pm

160

QC3- Inspect Part Finish

0.00



QC

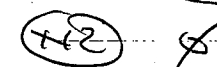
Memo

0.00

Quality Control

=> Sorloak

12 09-08-11



# Work Order ID 51195

August 6, 2009 2:22:54 PM



Page 4

Item ID: D3789-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 8/10/09

Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: 467

0.00



Packaging

Memo

0.00

Packaging

9/8/11 (12x) SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Pos-08-11  
MF 09-08-11

# Picklist Print

August 6, 2009 2:22:53 PM

Page 1 / 1

Work Order ID: 51195

Parent Item: D3789-5RevA

Parent Item Name: Clamp


Comments:

Start Date: 8/10/09

Required Date: 8/14/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1		Manufactured	No			100	f	760.9447	0.8842			
												
Lug Extrusion												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

760.94468

43722

213.01468

44529

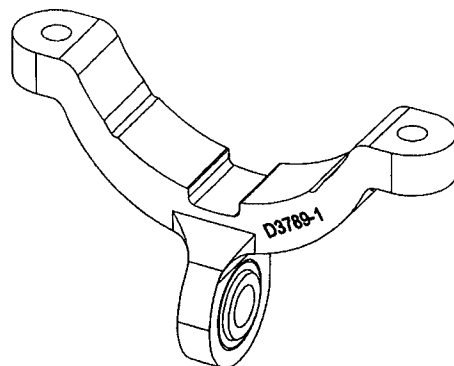
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45800

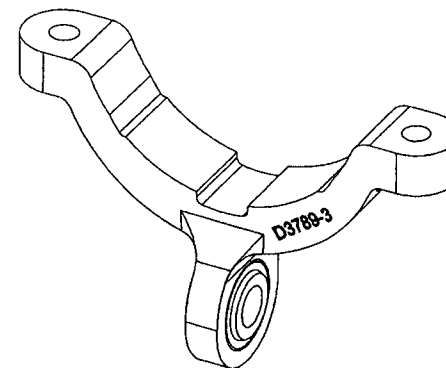
525.54

*DIP 8/08/10*

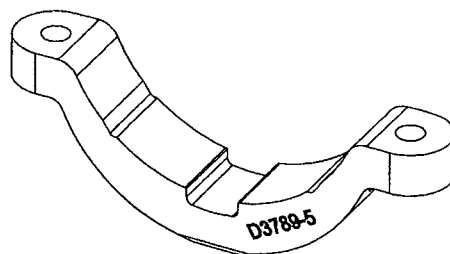
0.82 (F)



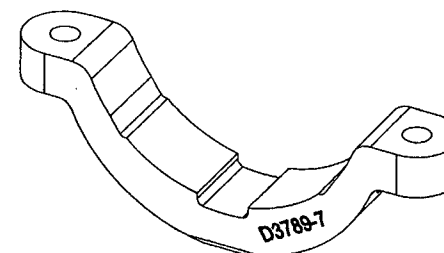
**D3789-1 CLAMP**



**D3789-3 CLAMP**



**D3789-5 CLAMP**




**D3789-7 CLAMP**

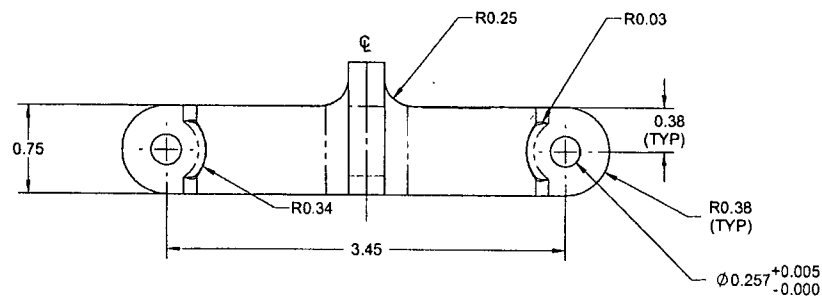
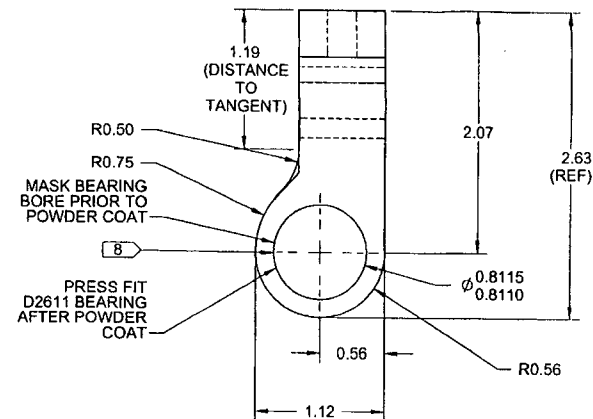
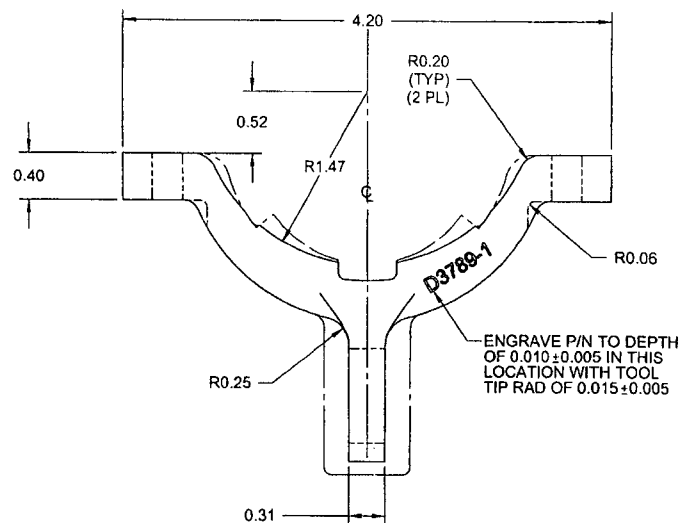
**DEO ATTACHED**

**RELEASE**  
08/12/21

**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMMETRICAL ABOUT  $\phi$

A		NEW ISSUE		HS	08.05.21	
REV.		DESCRIPTION			BY	DATE
DESIGN		HS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWN		HS				
CHECKED				DRAWING NO.		SHEET 1 OF 5
MFG. APPR.				D3789		
APPROVED				TITLE		
DE APPR.				CLAMP		
DATE		08.05.21		SCALE		NTS
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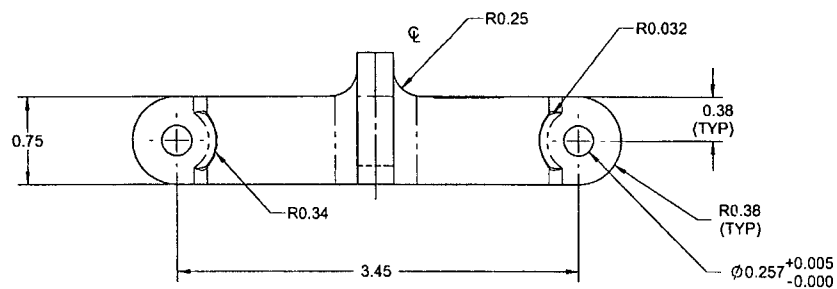
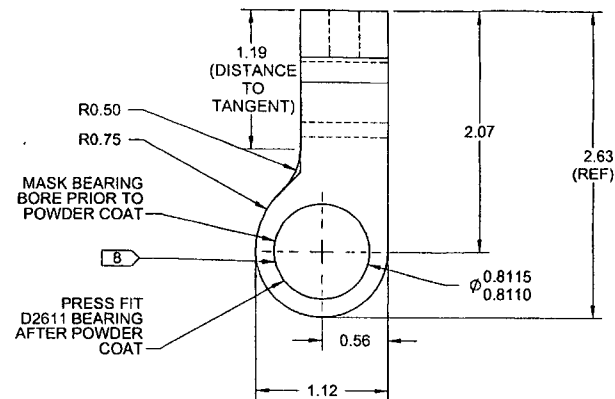
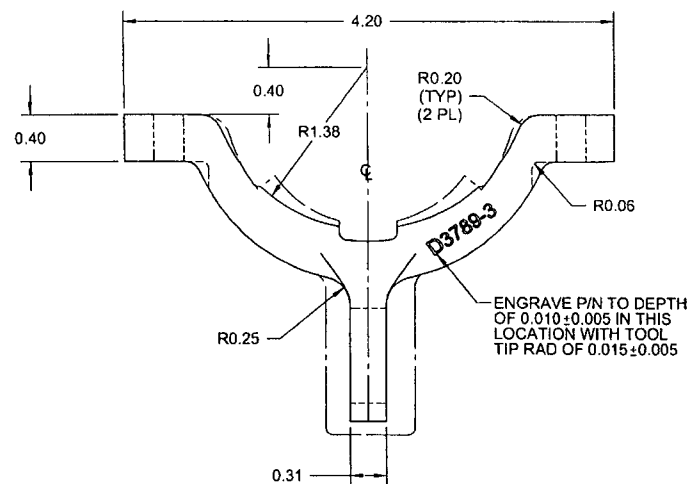
**D3789-1 CLAMP**

W/O 51195

DEO ATTACHED

RELEASED  
08/12/21

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**D3789-3 CLAMP**

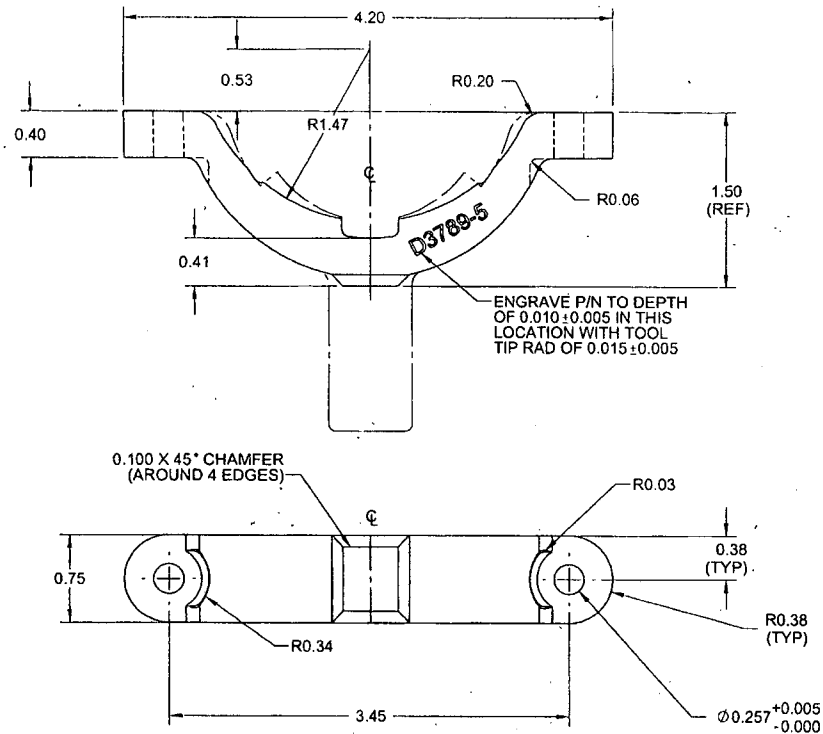
W1051195

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08/12/21

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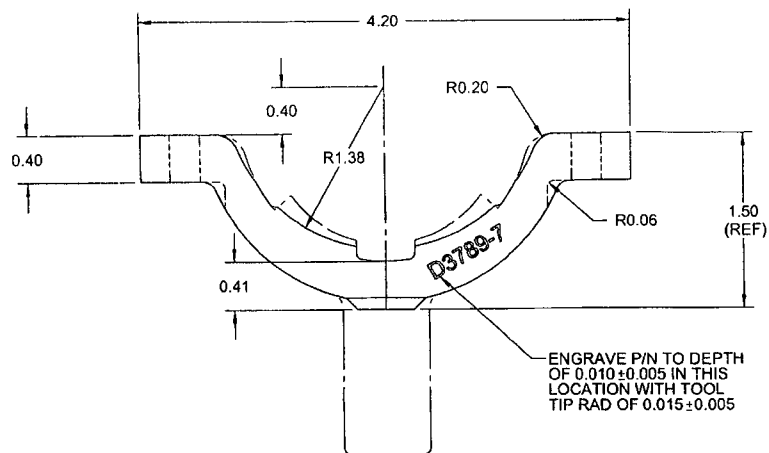
**D3789-5 CLAMP**

W/O 51195

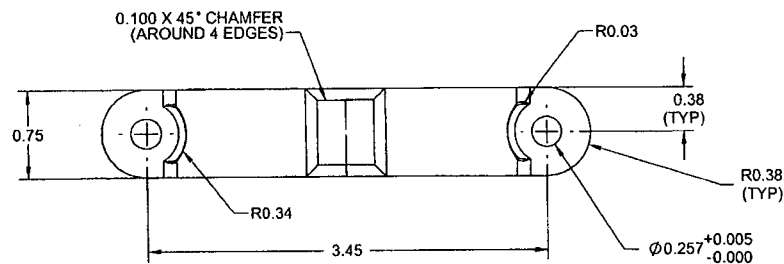
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ENGRAVE P/N TO DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION WITH TOOL TIP RAD OF  $0.015 \pm 0.005$





**D3789-7 CLAMP**

W/O S1195

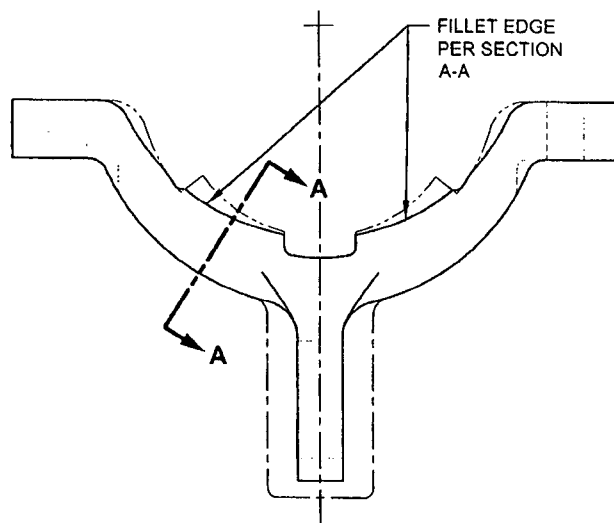
DEO ATTACHED

RELEASED  
28/12/21

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MFG. APPR.		D3789	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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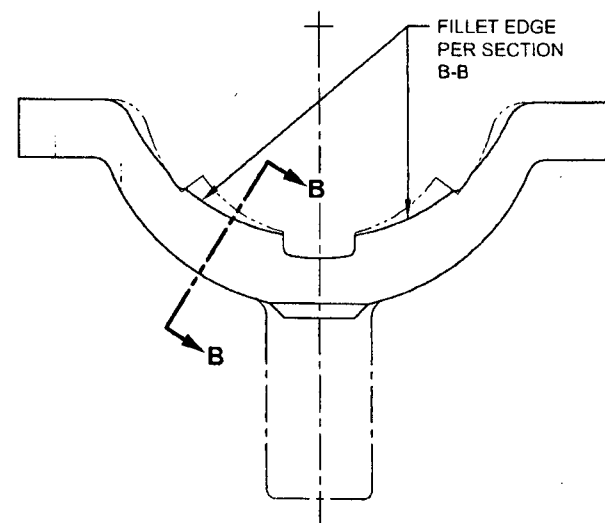
DRAWING NO. D3789	TITLE CLAMP	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED b	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23			

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



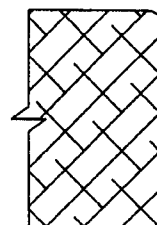
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

**RELEASED**  
09/25/24 *[Signature]*

W/051195

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DART AEROSPACE LTD		Work Order: 5195
Description: Clamp		Part Number: D3789-5
Inspection Dwg: D3789 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm 0.030$	4.203	✓			
0.53	$\pm 0.030$	0.522	✓			
0.40	$\pm 0.030$	0.395	✓			
0.41	$\pm 0.030$	0.415	✓			
1.50	$\pm 0.030$	1.499	✓			(REF)
R0.06	$\pm 0.030$	0.062	✓			
R0.20	$\pm 0.030$	0.20	✓			
R1.47	$\pm 0.030$	1.470	✓			
0.75	$\pm 0.030$	0.748	✓			
R0.34	$\pm 0.030$	0.34	✓			
3.45	$\pm 0.030$	3.446	✓			
0.38	$\pm 0.030$	0.370	✓			(TYP)
R0.03	$\pm 0.030$	0.03	✓			
R0.38	$\pm 0.030$	0.38	✓			(TYP)
$\phi 0.257$	$+0.005/-0.000$	0.258	✓			
0.100 X 45°	$\pm 0.010 / \pm 42^\circ$	0.101 X 45°	✓			

Measured by: DJI	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/08/10	Date: 09/08/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

